

Work Order ID 157863

Tuesday, February 28, 2017 10:06:43 AM

U/R

157863

Page 1

Item ID: D4842-041

Accept

N900040100

Setup Start

NS1

Revision ID: URF 16-692

POSITIVE
RECALL

Stop

NS2

Item Name: Lower Cutter Assembly

Start Date: 3/6/2017 Start Qty: 2.00

2

Cust Item ID:

F.A.I.R. COMPLETION

Required Date: 3/22/2017 Req'd Qty: 2.00

2

Customer:

REQUIRED

Reference: CONCESSION # QRS-107 FOL REV B PN 659540J00231

Approvals: Process Plan:

DAS
21
9-89

Date: FEB 28 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4842	REV B U/R
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OK of 17/2/28

110 Pick Kit

0.00

110

Packaging

Memo

0.03

Packaging

120

0.00

120

Small Fab

Memo

0.29

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces.

A/R LOCTITE 598: M136701

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.01

Quality Control

2. COMPLETION
REQUIRED

2x 17/03/03
740-8

17.03.28

FAI must be PERFORMED
To concession

QC APPROVAL
only.

DQA:

Date:

2017-04-08



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

APR 04 2017

Work Order update only



Work Order: <u>157863</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D4842-041</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No.		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
ADD NOTE & ENSURE MAX WIDTH of ASSEMBLY BASE DO NOT EXCEED 22.15mm. PER CONSTRUCTION QRS.107				@ 21.6 before paint. 21.92 after paint.				PD 17.03.09 Lead hand / Supervisor Approval Verification DAS 9-89 17.03.29	
								QC / QA Coordinator Approval	
								5.17/03/03	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 157863

Tuesday, February 28, 2017 10:06:43 AM

157863

Page 2

Item ID: D4842-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-692 Stop ***NS2***
Item Name: Lower Cutter Assembly
Start Date: 3/6/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/22/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

140

Packaging

Packaging

Identify as per dwg & Stock Location: QC office

0.00

Memo

POSITIVE RECALL

EFFECTIVE 17/03/14 **WITH** 5

RELEASED 9 **DATE** 17.03.29

~~17/03/29~~ **BE CREATED**

0.00

*** SEE BELOW ***

MATERIAL CERTIFICATION

0.03

REQUIRED

(concession)

① 17.03.29 PD

150

150

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

17/3/30 JD

*** ARC must be created by QA**

*** ARC must contain concession number**

*** Parts must be labeled with concession number**

*** Parts must have FAIR attached**

17/03/14
MAR 29 2017
5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Tuesday, February 28, 2017 10:06:46 AM

Page 1

157863

D4842-041

Required Date: 3/22/2017

Required Qty: 2.00

Comments: IPP REV:A 13.04.30 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.01 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4839-1		Manufactured	No				Each	7.0000		4			
D4839-1									**			17/03/03	DAS 36 9-89
Blade													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK128				7					
					141328			7		4			
D4842-1		Manufactured	No				Each	7.0000		2			
D4842-1									**			17/03/03	DAS 36 9-89
Lower Cutter Deflector													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CCK035				7					
					140905			7		2			
D4842-3		Manufactured	No				Each	6.0000		2			
D4842-3									**			17/03/03	DAS 36 9-89
Lower Cutter Body, LH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				qrtn				6					
					140906			6				157864	
D4842-4		Manufactured	No				Each	2.0000		2			
D4842-4									**			17/03/03	DAS 36 9-89
Lower Cutter Body, RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				qrtn				2					
					142317			2				B157865	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

Picklist Print

Tuesday, February 28, 2017 10:06:46 AM

Page 2

Work Order ID: 157863

157863

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 3/6/2017

Required Date: 3/22/2017

Start Qty: 2.00

Required Qty: 2.00

MS21042L08

Purchased

No

Each

840.0000

12

MS21042L08

Nut

★★

17/03/03 DAS
36
9-89

Location

Loc Qty

Loc Code

GA

503

m135274

18

m135978

485

ST303

337

m136643

160

m136851

177

MS27039-08-19

Purchased

No

Each

405.0000

12

MS27039-08-19

Screw

★★

17/03/03 DAS
36
9-89

Location

Loc Qty

Loc Code

GA

155

m135948

155

ST277

250

m136537

100

m136851

150

NAS1149FN832P

Purchased

No

Each

2,683.000

24

NAS1149FN832P

Washer

★★

17/03/03 DAS
36
9-89

Location

Loc Qty

Loc Code

GA

564

M135058

232

M136182

332

ST260a

1500

M136866

1500

ST263

619

M136182

619

Tuesday, February 28, 2017 10:06:46 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



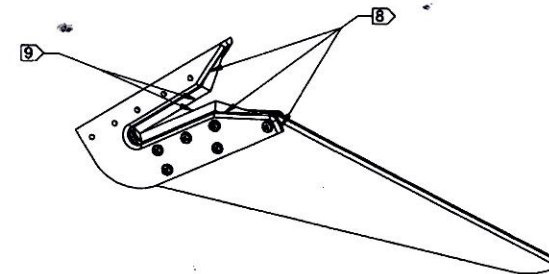
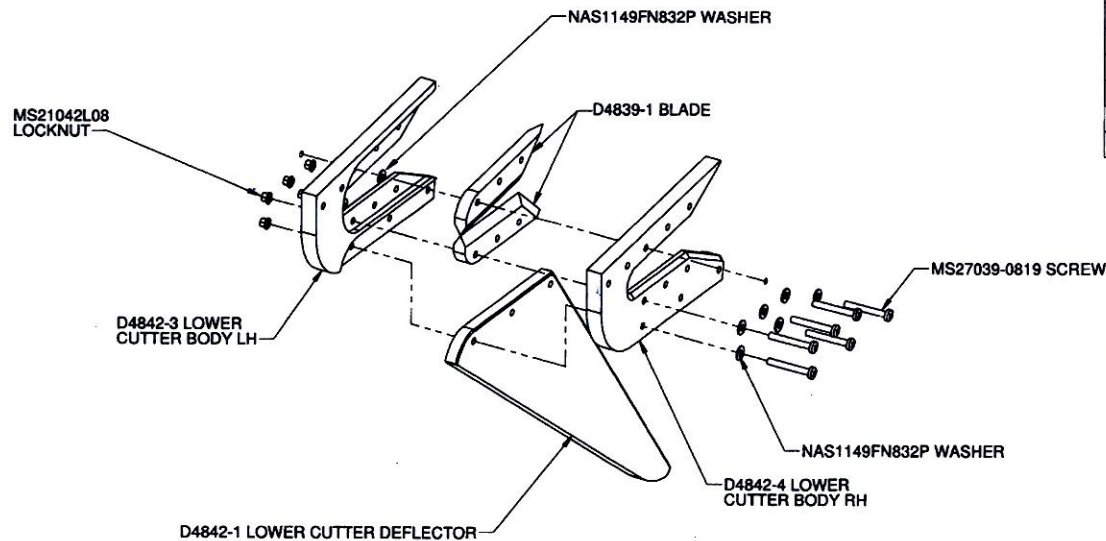
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4842-041	LOWER CUTTER ASSY
1	2	D4839-1	BLADE
2	1	D4842-1	LOWER CUTTER DEFLECTOR
3	1	D4842-3	LOWER CUTTER BODY LH
4	1	D4842-4	LOWER CUTTER BODY RH
5	6	MS21042L08	LOCKNUT
6	6	MS27039-0819	SCREW
7	12	NAS1149FN832P	WASHER
8	A/R	LOCTITE 598	RTV SEALANT



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157863 MWS
170228

D4842-041 LOWER CUTTER ASSEMBLY

UNDER REVIEW

URF 16-692 WM

16-12-21

RELEASED
2013-10-31

B	CORRECT TOLERANCES (ZN B1-2) (ZN B1-3, D2-3)	DW	13.10.17
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DW		
CHECKED	A.P.		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.10.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4842** REV. B
SHEET 1 OF 6
TITLE **LOWER CUTTER ASSY** SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4842-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 2.79 lbs (1.26 KGS)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

10) CONCEPTION 400600061786 Assembled width 22.15mm +0.05/-0.35mm.

		Supplier Concession				PAGE 1 of 2	PLANT Leonardo Helic. - Vergiate
Supplier NC N.	AWC 006/01	Date	02.02.2017	AW Concession	400000061786	Purchase Order	4801373666
P/N	6F9540V00231			Grade/Category	NC	Drawing Issue	
Part Description	PROTECTR, CCP ASSY LOWER			Batch Quantity	20,000	Defective Quantity	20,000
AW NC	GUIDO BRUSCINO					A/C Type/Model	AW6
Supplier	DART AEROSPACE LTD					Contract	
Defect FO01 - Wrong dimensions - * 02.02.2017 09:40:16 GUIDO BRUSCINO (40067) * see supplier document attached - B/N quantities and PO's listed in the Cause of Defect							
				Repetitiveness (same P/N - Defect Code) NO ☒ YES ☐			
ENGINEERING Evaluation and Proposal							
Engineering Evaluations, including Specialist inputs:				Investigation Report n.		Compliance Report n.	
* 10.02.2017 18:01:48 MARCELLO STEFANELLI (9273) * The part is acceptable with the action proposed by the supplier applied.							
Classification of Deviation from Type Design i.a.w. EASA Part 21A.91 : Minore/B							
Defect effect				Limitations			
	Before Repair	After Repair					
Safety	☐ YES	☐ YES	☐ NO	☐ YES (to specificity) ☒ NO			
Life or Duration	☐ YES	☐ YES	☐ NO				
Strenght	☐ YES	☐ YES	☐ NO				
Performances	☐ YES	☐ YES	☐ NO				
Interchangeability	☐ YES	☐ YES	☐ NO				
Reliability	☐ YES	☐ YES	☐ NO				
Maintainability	☐ YES	☐ YES	☐ NO				
Installability	☒ YES	☐ YES	☒ NO				
Testability	☐ YES	☐ YES	☐ NO				
Only Appearance	☐ YES	☐ YES	☐ NO				
No Effect	☐ YES	☐ YES	☐ NO				
Repair Proposal:				Decision			
* 10.02.2017 18:01:48 MARCELLO STEFANELLI (9273) * See attached supplier document.				☐ Use rep. with spec.repair(not yet applied) ☒ Use repaired with known repair(yet applied) ☐ Use As Is ☐ Use repaired for tests only(see Limitations) ☐ Use As Is for tests only(see Limitations) ☐ Scrap			
Concession Classification		☐ MAJOR ☒ MINOR		Re-submit after Repair		☐ YES ☒ NO	
Mark part with Concession		☒ NO ☐ YES		Method :			
ATE	MARCELLO STEFANELLI		CPE			Date	10.02.2017
Checks and tests to be performed							
Repair registration							
with repair WO		☒ Number:					
Repair Evaluation:							
Final Decision							
S/N	Use As Is (UTI)	Use Repaired (RIL)	Scrap (SCA)	S/N	Use As Is (UTI)	Use Repaired (RIL)	Scrap (SCA)
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
Not Serialized	Use As Is (Q.ty)	Use Repaired (Q.ty)	Scrap (Q.ty)				
Role	AW ATE	AW CPE	Inspection Clearance Repair	Quality	Customer	MoD or Authority Representative	
Signature	MARCELLO STEFANELLI						
Date	10.02.2017						

Supplier NC N.	AWC 006/01	Date	02.02.2017	AW	400000061786	Purchase Order	4801373666
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DEFECT 0001**FO01****Wrong dimensions**

attachment

Manuf. Doc. N.	AWC 006	Date		AW Doc. N.		Purchase Order	4800671131 4800722284 4801147764 4801186922 4801218851 4801288960 4801373666
AW P/N	6F9540V00231	S/N / Batch Number	B109195 Qty. (1) B133355 Qty. (2) B134314 Qty. (1) B134315 Qty. (1) B134842 Qty. (1) B137492 Qty. (1) B137355 Qty. (2) B137816 Qty. (1) B137818 Qty. (1) B137817 Qty. (1) B140379 Qty. (3) B140381 Qty. (2) B147002 Qty. (2) B150786 Qty. (1)	Grade	A	AW Drawing Issue	B
Description	Lower Cutter Assy			Batch Qty	20	Defective Qty	20
Manufacturer	Dart Aerospace			Model	AW169		
Defect(s) Description							
Leonardo has informed Dart that there are interference issues installing the lower cable cutter D4842-041 onto the Leonardo interface bracket.							
				Department	Inspector	Signature	Date
				Quality	DAS 16 9-89		2017/02/01
Defect(s) Cause							
The Lower Cutter body has a dimension of 10.9 +0.25/-0.00 mm. This dimension was reported as part of the approved FAI and has been met with all delivered product.							
				Department	Inspector	Signature	Date
				Quality	DAS 16 9-89		2017/02/01
Corrective Action						Complete Before	
In order to mitigate the interference issue for Leonardo, Dart is proposing to remove sufficient material to make the overall installation dimension at 22.15 mm +0.05/-0.35.							
				Department	Inspector	Signature	Date
				Quality	DAS 16 9-89		2017/02/01

For "MANUFACTURER" SUPPLIERS ONLY
ENGINEERING evaluation and proposal

Engineering evaluation

Investigation report

n.....

Compliance report

n.....

Dart's position is that this change will not impact the structural substantiation presented in Report DA169-4 for the lower cutter body since this is not a section with the lowest margin. Therefore removing 0.3 mm max from each part will not impact the structural integrity of the lower cutter assembly. The dimension on the cutter body part D4842-3/-4 will be 10.80 +0.00/-0.200.

The dimension change of the two lower cutter body parts mating, plus the sealant, anodize and primer layers will be defined as a dimension of 22.15 +0.05/-0.35 mm on the assembled lower cutterbody and will be incorporated into the D4842 drawing for inspection.

	Defect effects		Limitations
	Before any repair	After any repair	
Safety	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☒ yes	☐ yes ☒ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal		Decision to use	
None		☐ Use repaired with specific repair	
		☐ Use repaired with known repair	
		☐ Use as is	
		☐ Use repaired for tests (see Limitations)	
		☐ Use as is for tests (see Limitations)	
		☒ Scrap	
Concession Classification			
☒ Major ☐ Minor		Submit after repair	
		☐ yes ☐ no	